

Claims

1. Process for producing a strip of aluminium or an aluminium alloy with a textured surface, whereby a cold rolled strip (12) is passed through the roll gap (39) of two textured rolls (38, 40) bearing a roughness pattern and the roughness pattern is transferred to the surface of the strip (12) as a result of the force of the textured rolls (38, 40) acting on the strip (12),
characterised in that,
immediately after the cold rolled strip (12) emerges from a cold rolling mill (17), it is passed through the roll gap (39) of two texturing rolls (38, 40) and the textured strip (12) is coiled.
2. Process according to claim 1, characterised in that the cold rolled strip (12) is drawn through roll gap (39) and the texturing rolls (38, 40) are turned by the tension applied to the strip (12).
3. Process according to claim 1, characterised in that the texturing rolls (38, 40) are driven in an active manner.
4. Process according to one of the claims 1 to 3, characterised in that the texturing rolls (38, 40) are set at a constant roll force.
5. Process according to one of the claims 1 to 4, characterised in that the texturing rolls (38, 40) are roughened using the electrical discharge texturing (EDT) method.
6. Process according to one of the claims 1 to 4, characterised in that the texturing rolls (38, 40)

exhibit a roll grind comprising a plurality of parallel grooves distributed over the outer face of the rolls.

7. Unit for producing a cold rolled strip of aluminium or an
5 aluminium alloy with a textured surface, featuring a cold rolling mill (17),

characterised in that,

- 10 a texturing roll stand (28) with texturing rolls (38, 40) is situated immediately after the cold rolling mill (17), downstream in the direction of rolling (x).

8. Unit according to claim 7, characterised in that the
15 texturing rolls (38, 40) are connected up to a drive facility.

9. Unit according to claim 7 or 8, characterised in that the
20 texturing rolls (38, 40) in the texturing roll stand (28) are supported by intermediate rolls (42, 44) and the intermediate rolls (42, 44) are supported by backing rolls (46, 48).

10. Unit according to claim 9, characterised in that a
25 plurality of sets of backing rolls (46, 48) are arranged over the width of the intermediate rolls (42, 44).

11. Unit according to claim 9 or 10, characterised in that
30 the backing rolls (46, 48) are connected to hydraulic pistons (58) set at constant force.

12. Unit according to claim 7 to 11, characterised in that the texturing roll stand (28) is mounted in the framework (26) of the cold rolling mill (17).